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RBST2162
Job Sheet 194414



Part No: RBST2162

Job Qty: 1 pcs

Part Name: Drill Press Tri-Roller Staking Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/2/19

Job Tracking No:

Due Date: 6/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 15162*

Note: DWG RBST2100 REV 7 IPP Rev. A 19.04.04 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	6/20/19		0.00	1.00	Small Fab - 1		<i>MLC</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	6/20/19		0.00	0.00	QC 5 - 10		<i>DAS</i> JUN 28 2019 68 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68	<i>AT</i>	
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	1 pcs	6/20/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S194737



Part: RBST2162

Job No: 194414

Serial No/Batch: S194737

Revision: 7

Inspector:

Exp Date:

Instructions:

Date: 06/28/19

					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	6/20/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	JUN 28 2019
					QC 21 - SA - 53	

DAS
70
9-89

Part Op 110 - Small Fab-3 (Small Fab) -Assemble as per DWG. Sheet 1
 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location:_____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-832-1/4	Set Screw	1 Ea (1 ea)	110-Small Fab - 1	5165060
RBST2162-1	Roller Fixture	1 pcs (1 ea)	110-Small Fab - 1	5185217
RBST2162-11	Primary Seat	1 pcs (1 ea)	110-Small Fab - 1	5185690
RBST2162-15	Locating Pin	1 pcs (1 ea)	110-Small Fab - 1	5185903
RBST2162-3	Retainer	1 pcs (1 ea)	110-Small Fab - 1	5180331
RBST2162-5	Roller	3 pcs (3 ea)	110-Small Fab - 1	5188505
RBST2162-7	Guide	1 pcs (1 ea)	110-Small Fab - 1	5186139
RBST2162-9	Pin	1 pcs (1 ea)	110-Small Fab - 1	5184180

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	188-FPSS-832-1/4	1	108	0
	RBST2162-1	1	0	0
	RBST2162-11	1	0	0
	RBST2162-15	1	0	0
	RBST2162-3	1	0	0
	RBST2162-5	3	0	0
	RBST2162-7	1	0	0
	RBST2162-9	1	0	0

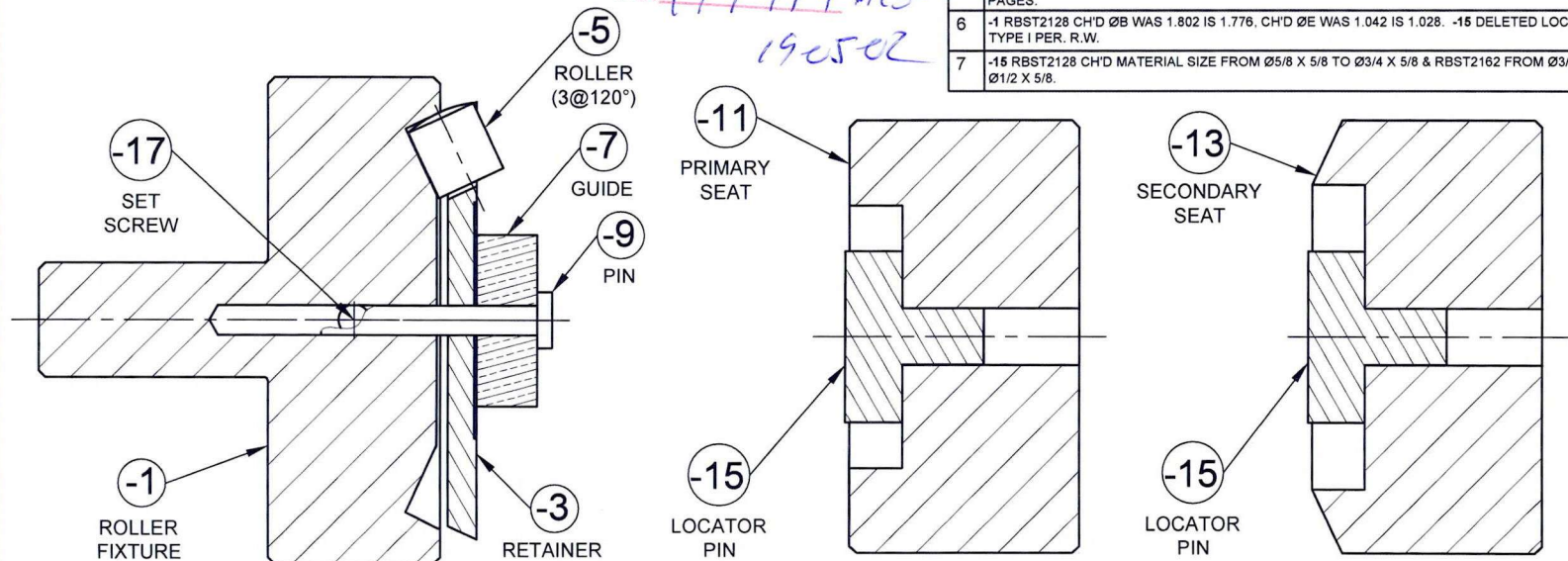
Part Specifications

Specifications could not be found.

Plex 5/2/19 7:55 AM Dart.lajeunesse.marie

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194414 MLC
190502



NOTES

1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
3. FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INSPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW
4	-5 CH'D ROLLER RADIUS FROM .005 - .010, TO .015 - .020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC	
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW
6	-1 RBST2128 CH'D ØB WAS 1.802 IS 1.776, CH'D ØE WAS 1.042 IS 1.028. -15 DELETED LOCATING PIN TYPE I PER. R.W.	9/10/13	CFS	GE
7	-15 RBST2128 CH'D MATERIAL SIZE FROM Ø5/8 X 5/8 TO Ø3/4 X 5/8 & RBST2162 FROM Ø3/8 X 5/8 TO Ø1/2 X 5/8.	11/5/13	JAG	GE

BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
406-310-403-101	RBST2120
412-010-427-101	RBST2128
406-312-100-101	RBST2162

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	ROLLER FIXTURE	SEE CHART	2
		-3	1	RETAINER	SEE CHART	3
		-5	3	ROLLER	SEE CHART	4
		-7	1	GUIDE	SEE CHART	5
		-9	1	PIN	SEE CHART	6
		-11	1	PRIMARY SEAT	SEE CHART	7
		-13	0 or 1	SECONDARY SEAT	SEE CHART	8
		-15	1 or 2	LOCATING PIN	SEE CHART	9
B/O		-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S

RED BARN MACHINE	
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; ASSEMBLY	
DWG NO. TOOL# (see chart above)	REV 7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	DRAWN BY: PERRITT
DECIMALS .XXX ± .005	APPROVED D Weil
XX ± .01	HEAT TREAT LISTED PER ITEM
X ± .1	FINISH LISTED PER ITEM
ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON BEARING SEE ABOVE	
SCALE NTS	DATE 1-4-08
SHEET 1 of 9	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					